

Date: Tuesday, 3/20/2007 2:36:06 PM
User: Kim Johnston

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 31387 <i>2</i>	
Estimate Number : 10033	
P.O. Number : <i>NIA</i>	Part Number : D6101003
This Issue : 3/20/2007 S.O. No. : <i>NIA</i>	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25349	Material : <i>NIA</i>
Written By : _____	Due Date : 6/1/2007
Checked & Approved By : <i>07.03.20</i>	Qty: <i>60</i> Um: Each
Comment : Est. A: 01.05.04 New Issue EC	

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *3385*

a) Description: Alluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

07/03/22

120 60

2.0 D6101003P 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : *60* ~~120.0000~~ Each(s)
7075-T7351 2X6.25X7.875

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

07/06/12 60

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK
Ensure Material certification comply to Dwg D6101

07/06/19 60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 08/06/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 2:36:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 31387

Part Number: D6101003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

inf 07/06/19 *GB*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(60)

Comment: FINAL INSPECTION/W/O RELEASE

Done 19

Job Completion



U 87-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

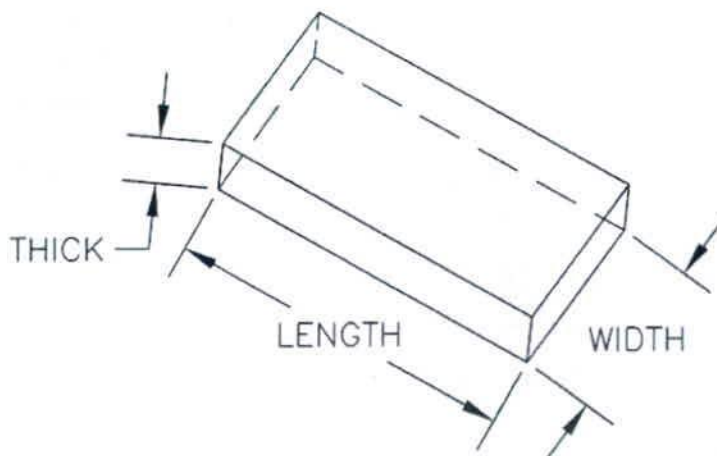
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31387

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ALCAN
ROLLED PRODUCTS

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164 USA



A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL
60131



A M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL
60131

A M CASTLE 974503 1512 INCLUSION SERIAL#: 20070430974503 PAGE 2 OF 2

CUSTOMER PURCHASE ORDER NO. & ITEM 01-83993				ALCAN ORDER NO. 113-581105	
ALLOY 7075	CLAD 00	TEMPER T7351	GAUGE 2.00000	WIDTH 48.500	LENGTH 144.500
ITEM ORDERED DIST. AEROSPACE/MILITARY SPEC PLATE, SAWED MILL					
CUSTOMER SPECIFICATION AMS-QQ-A-250/12					
PART NUMBER		B/L NUMBER 974500		DATE SHIPPED 04/30/07	
WEIGHT SHIPPED 5.720		NO. OF PIECES 4		GOVT. CONTRACT NO.	

CERTIFICATION

"ALCAN Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on ALCAN Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

ALCAN ROLLED PRODUCTS

P.O. BOX 68

RAVENSWOOD, WV 26164 USA

LaDonna B. Smith
LaDonna B. Smith - Quality Manager

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS										
			MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX									
ACTUAL CHEMICAL COMPOSITION																			
337471 C SI= 0.06 FE= 0.18 CU= 1.40 MN= 0.05 MG= 2.55 CR= 0.19 ZN= 5.63 TI= 0.02 OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																			
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																			
CHEMISTRY BY OES: ARKSPARK																			
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																			
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																			
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																			
"END OF CERTIFICATION"																			
C H E M I C A L C O M P	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	EACH MAX	TOTAL MAX
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			

ALCAN
ROLLED PRODUCTS

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164 USA

SHIP
TOA M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

SOLD
TOA M CASTLE & CO
3400 NO WOLF ROAD
FRANKLIN PARK IL

60131

A M CASTLE 974503 1512 INCLUSION SERIAL#: 20070430974503 PAGE 1 OF 2

CUSTOMER PURCHASE ORDER NO. & ITEM 01-83993				ALCAN ORDER NO. 113-581105		CERTIFICATION "ALCAN Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on ALCAN Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." ALCAN ROLLED PRODUCTS P.O. BOX 68 RAVENSWOOD, WV 26164 USA <i>LaDonna B. Smith</i> LaDonna B. Smith - Quality Manager
ALLOY 7075	CLAD. 00	TEMPER T7351	GUAGE 2.00000	WIDTH 48.500	LENGTH 144.500	
ITEM ORDERED DIST. AEROSPACE/MILITARY SPEC PLATE, SAWED MILL						
CUSTOMER SPECIFICATION AMS-QQ-A-250/12						
PART NUMBER		B/L NUMBER 974500		DATE SHIPPED 04/30/07		
WEIGHT SHIPPED 5,720		NO. OF PIECES 4		GOVT. CONTRACT NO.		

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.									
337471	LT	2	***** T7351 71.9	73.5	60.8	63.7	***** 11.5	11.5	40.5	41.6									
<p>ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS</p> <p>MIL-STD-2154 100%SONIC TESTED MINUS DEAD ZONE CLASS A</p> <p>ALSO CONFORMS TO AMS 4078E, ASTM B209-04 & ASTM B-594</p> <p>ALSO CONFORMS TO BSS 7055 CL A SONIC</p> <p>CASTLE METALS CORP DATE RCVD 5-4-07 IAC 6857 APPROVED BY LC</p>																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
	SEE ACTUAL CHEMICAL COMPOSITION																		
ALUMINUM REMAINDER																			

